Quality Control

Work Orde August-28-13 12		5229		*106	5229*						Page 1
Item ID: Revision ID:	D4017-041			Accept	*N900	040	100)* s	Setup Star	*N	S1*
	Short Basket B	Base Assembly (350)							Stop	*N.	S2*
Start Date:	8/28/13	Start Qty: 1.00	*1*	٠	Cust Item I	D:					
Required Date:	8/28/13	Req'd Qty: 1.00	*1*		Customer:						
Reference:			-								
Approvals:	Process Pla	n: MLJ	Date: \3-08-3	O Tooling:	Da	ate:		F	tun Star	1/	R1*
	QC:		Date:	_ SPC (Y/N):	Da	ate:	···		Stop	*N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
D4017	E										
100 *1 Large Fab		Weld per dwg A/R S.S. Large Fab Memo	rod Batch:	0.00					SY	13-1	0-/
Large Fab			ribs, weld as per dwg D4 before welding mesh***	4017 using DT9610B							
			mesh on basket as per dv clear fasteners holes on the		o fit if necessary						
			ge (3) and Mounting brack to locate hinge and bracke								
	·	4- Weld D4	672-3 blanking plates as p	er dwg							
110		QC9- Inspect visual per	QSI004- Fusion Welds	0.00	·				9		DAS 9
*11 0 *		Memo		0.00					BIC	-21	9-89

NCR:	Yes	1	No
INCIN.	163	,	110

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORI	MANCE / UP	DATE	QA Closed:	 Date:	The state of
						DISPOSITION				A CAUNCT DO		· ·	
Work Ord	er:					DISPOSITION				AGAINST DE	PAKTIVIENT	/PROCESS	
	•					Rework]		Skid-tube	Crosstube		Water Jet 🗌	Engineering
Part	No.					Scrap			Machining	Small Fab	-1	d. Eng. Coor.	Quality
						Use-as-is	4	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR	No.					Work Order Update	J	i	Large Fab	Composite]	Supplier	
Root					Descri	ption of work order update	T	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling	\vdash												,
Operator	\vdash												
Material	-												
Setup													·
Other	\vdash												
Process Supplier	\vdash		-										
Training	\vdash	٠											
Unapproved	\vdash				٠								
				1	1	F	AUL	T CATE	GORY		1		
Land	ing (Gear				General							* ***
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre N	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct	Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/i	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		
9	L	Heat Trea	at			Countersink	Ш	Mislabe	led		Positioned V	Vrong	_
		Inspectio		Tube		Cut Too Short	Ш	Misread			Power Loss/	Surge	Other
	\perp	Ripples in	n Bend			Drill Holes		Offset					,
	L	Torque W	Vaves in E	xtrusio	n 📙	Drawing		ł	Calibration				
		Turning S	equence			Finish		Out of S	iequence				,

Outside Dimensions

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde				*106	5229*					· · · · · · · · · · · · · · · · · · ·	Page 2
Item ID: Revision ID:	D4017-041			Accept	*N900	040	100)* s	etup Star	* *N	S1*
Item Name:	Short Basket	Base Assembly (350)							Stop	*N	S2*
Required Date:	8/28/13 8/28/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*	·	Cust Item I Customer:	D:					
Reference:							_	R	tun Star	't *NI	R1*
Approvals:	Process P	lan:	Date:	_ Tooling:	Da	ate:			64		T I
	QC:		Date:	_ SPC (Y/N):	Da	ate:			Sto	*N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		QC5- Inspect part compl	eteness to step on W/O	0.00							
120 QC Quality Control		Memo		0.00					Bro	· A	DAS 9 9-89

125

Pressure Wash per QSI005 4.3

0.00

125
HandFinish
Hand Finishing

Memo

0.00

1 26, 13.10-21

											DQA:	Date	
NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UP	DATE	QA Closed:	Date	
							_				QA Closea:	Date	
Work Orde	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIN OIG	-					Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering
Part I	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is	i		noforming	Finishing	4	re/Packaging	Other
NCR I	No.					Work Order Update			Large Fab	Composite	1	Supplier	1
	•					· 			· —				
Root	•				Descri	ption of work order update	ı	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling	Ш											<u> </u>	
Operator	Ш												
Material	Ш												
Setup													·
Other	Ш												
Process													·
Supplier	Ш										·		
Training													
Unapproved									<u> </u>				
						F/	AUL	T CATE	GORY				
Landi	ng G	iear				General					•		-
	—-	Bending				Bend		Grain			Ovalized	<u> </u>	Pressure/Forced
	Ш	Centre No	ot Concer	ntric to (D/S	BOM/Route	Ш	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Ш	Cracks				Broken/Damaged	Ш	Inspecti	on Incomplete		Part Incorre	ct	Weld
	-	Crushed/	Crimped			Burrs		Instructi	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination	Ш	Mainte	nance		Part Moved		
	Ш	Heat Trea	t			Countersink	Ш	Mislabe	led	<u></u>	Positioned V	Vrong	=
		Inspection	n Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Work Orde		6229		*106	5229*							Page 3	3
Item ID: Revision ID: Item Name:	D4017-041 Short Basket I	Base Assembly (350)	·	Accept	*N900	<u>040</u>	100)* s	Setup S	Start Stop	*N:	S1*	······ j
Start Date: Required Date: Reference:	8/28/13 8/28/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item 1 Customer:	ID:					, 41		
Approvals:	Process Pla	in:	Date:	Tooling: SPC (Y/N):		ate:		F		Start Stop		R1* R2*	
Sequence ID/ Work Center II 130 *130*	D	Operation Description White Gloss(Ref:4.3.5.2)		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	. N	Reject Number	Insp. Stamp	DAS 34
Powder Coating		IST COAT: START TIM OVEN TEM FINISH TIM ********* 2ND COAT START TIM OVEN TEM	ME: /30 IPERATURE: 400 ME 200 ********** 2nd coat if ne	0.00 of hinge (3) prior to powde									9-89
140 *140* QC		QC3- Inspect Part Finish Memo	• • **	0.00				14	(<u> </u>	HL	13/10	122

Memo

Quality Control

NCR:	⁄es	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UPE	DATE			
								•			QA Closed:	Date	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
:						Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	1	nitial	Acti	ion	Sign &		·
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved						· .	A15	T CATE	COPY				
Landi	nø G	Gear				General	HUL	.I CATE	JOK I		•		·· -
		Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection	Crimped it n Strip in		o/s	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misreac	on Incomplete ions Incomplete/U nance led	inclear	Ovalized Over/Under Part Incorred Part Lost/Mil Part Moved Positioned W Power Loss/S	t ssing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	L	Ripples in	Bena		<u>L</u>	Drill Holes	L	Offset					

Out of Calibration
Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

Work	Ord	der I	D	106	229
Assessed 2	0 12	12.52	.01	DM	

106229

Page 4

August-28-13	12:53:04 PM			1176	1//31					
tem ID: Revision ID: Item Name:	D4017-041 Short Basket	Base Assembly (350)		Accept	*N900	04010	ገ በ *	Setup Sta	I VI	S1* S2*
Start Date: Required Date Reference:	8/28/13 : 8/28/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item II Customer:	D:				
Approvals:		an:	Date:	Tooling: SPC (Y/N):		nte:	·	Run Sta	n '' \(\bar{V}\)	R1* R2*
Sequence ID/ Work Center I 150 *150* HandFinish Hand Finishing	D ·	Operation Description Assemble as per dwg Memo		Set Up/ Run Hours 0.00	Tool ID	Tool # Pla Co	de Qty	t Reject Qty	Reject Number	Insp. Stamp
*160 *160* QC Quality Control		QC5- Inspect part compl	eteness to step on W/O	0.00	·					Mn/13.10.
*170 *170* Packaging		Identify as per dwg & St	ock Location: W(O	0.00	1035-041	B108 (30	j <u> </u>	., K	/ Jel	13/10/2

NCR: Y	'es / 1	No			WORK ORDER NON-C	ON	FORM	MANCE / UPDA	ATE			. ,
							4			QA Closed:	Dat	e:
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
					Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo				Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
NCR N	lo				Use-as-is Work Order Update		Thern	noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root				Descri	ption of work order update	In	itial	Actio	n	Sign &		
Cause	Da	te Step	Qty		or Non-conformance	Chie	ef Eng	Descrip	tion	Date	Verification	QC Inspector
Doc/Data			1									
Equip/Tooling			İ									
Operator										ļ		,
Material												· ·
Setup	_		1			ł						
Other												
Process	_											
Supplier												
Training						1						
Unapproved										<u> </u>		
						AULT	CATE	GORY				
Landir	ng Gear			_	General	\Box	.			1	Г	¬。
ŀ	Bend	_		~ 	Bend BOM/Bouts		Grain		ļ	Ovalized		Pressure/Forced
		re Not Cond	entric to	^{0/5} -	BOM/Route	\vdash	Hardwa		<u> </u>	Over/Under	 	Temperature/Cure Weld
	Crac			<u> </u>	Broken/Damaged	\vdash	-	on Incomplete	-laan	Part Incorred	<u>-</u>	
	_	ned/Crimpe	a	<u> </u>	Burrs	-		ions Incomplete/Und nance	clear	Part Lost/Mi	ssing [Wrong Stock Pulled
	Cuffs			-	Countersink	\vdash			<u> </u>	Part Moved	Irona	
	—	Treat	in Tube	—	Countersink	\vdash	Mislabe		<u> </u>	Positioned V	· ·	Other
		ection Strip	m rube	<u> </u>	Cut Too Short Drill Holes	-	Misread Offset	ı	<u> </u>	Power Loss/	ourge	Tottlet
		es in Bend	. Frateriosis	_	-	\vdash		Calibration			-,-	
	Llorq	ue Waves ir	i EXTrusio	T .	Drawing		Jul Of (Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord August-28-13				*106	3229*							Page	; 5
Item ID: Revision ID: Item Name:	D4017-041 Short Basket	Base Assembly (350)		Accept	*N900	040°	100	* s	•	art 🛨	NS NS	S1* S2*	
Start Date: Required Date Reference:	8/28/13 : 8/28/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:							
Approvals:	Process Pl	lan:	Date:	Tooling:		nte:		R		art *	NI NI	R1* R2*	
Sequence ID/ Work Center I 180 *180* QC Quality Control	D	Operation Description QC21- Final Inspection - Memo	Work Order Release	Set Up/ Run Hours 0.00	Tool ID		Plan Code	Accept Qty	Reject Qty	Reje Num	ber	Insp. Stamp	

		DQA:	Date:	
Var. / Na	MADE ARREST AND CONFORMANCE / LIREATE		•	

NCR: '	Yes	/ No				WORK ORDER NON-	COR	NFOR	MANCE / UPI				
											QA Closed:	Date	•
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	,
Part I	- _ No.					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	1.	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	1	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved							AUL	T CATE	GORY				
Landi	ng G	ear				General							······································
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion					Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	ion Incomplete ions Incomplete/U enance eled	Jnclear ·	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing /rong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
ľ	1 l'	Torque W	aves in E	xtrusio	n I	Drawing	1 1	Out of 0	Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Page 1

Work Order ID: 106229

106229

Parent Item: D4

D4017-041

D4017-041

Parent Item Name:

Short Basket Base Assembly (350)

Start Date: 8/28/13

Required Date: 8/28/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP RevA: new issue DD 09.11.30 verified by:EC

IPP Rev:B as

per dwg RevA DD 10.03.06 verified by:EC

IPP Rev:C as per dwg

RevB DD 10.04.16 verified by:EC

IPP Rev:D as per dwg revC DD

66475

10.08.18 verified by:EC

by:EC IPP Rev:E 10.11.04 added pressure wash IPP REV:F 12.07.24 AS PER DWG REV.D DD

DD verf:EC VERF:EC

IPP REV:G 13.08.21 DWG REV.E / ECN 13-624 DD

VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4672-3		Manufactured	No			100	Each	8.0000	2	2			
D4672-3 Blanking Plate									** 7	3879	7/5 → 2) <u>v</u>	
				Location		<u>Loc</u>	<u>Qty</u>	Loc Code			-1	出13	10.09
				WA005			8		_		_		•
					87915		8		_				
D4017-1		Manufactured	No			100	Each	1.0000	1	1			
D4017-1									** 2	3107	749 -	SY	13 · 10 · 0
				<u>Location</u>		<u>Loc</u>	<u>Oty</u>	Loc Code					
				WA006			1		_		_		
					86015		1		_				
D4017-3		Manufactured	No			100	Each	2.0000	1	1			
D4017-3									** -	B 107	1750	SY	13.10.0
				Location	!	Loc	Oty	Loc Code					
				WA005			2						
					105160		1 .		_				,

1

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-C	CONFO	ORI	MANCE / UPDA	TE			
											QA Closed:	Date:	
Work Orde	er:					DISPOSITION				AGAINST DEF	PARTMENT	/PROCESS	
Part I	•					Rework Scrap				Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR I	•					Use-as-is Work Order Update	Th	Thermoforming Finishing Large Fab Composite				re/Packaging Supplier	Other
Root					Descri	ption of work order update	Initia	al	Action		Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Chief (Eng	Descripti	ion	Date	Verification	QC Inspector
Doc/Data													-
Equip/Tooling			ļ										
Operator										1			
Material										1			
Setup										Ī			
Other										1			
Process										1			
Supplier			İ							j			· ·
Training		[1							Ī			
Unapproved													
						F/	AULT CA	ATE	GORY				
Landi	ng (Gear				General							-
		Bending				Bend	Gra	in			Ovalized		Pressure/Forced
		Contro N.	at Camaa.		o/s	DOM/Doute	П				O /		T

Centre Not Concentric to O/S |BOM/Route Hardware Over/Under tolerance Temperature/Cure Broken/Damaged Inspection Incomplete Weld Cracks Part Incorrect Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved Countersink Mislabeled Heat Treat Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Other Power Loss/Surge Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Wave/Twist in Tube Folio Outside Dimensions

August-28-13 12:53:08 PM

Work Order ID: 106229 *106229* Parent Item: D4017-041 *D4017-041* Required Date: 8/28/13 Parent Item Name: Short Basket Base Assembly (350) **Start Date:** 8/28/13 Required Qty: 1.00 Start Qty: 1.00 D4017-5 100 Each 1.0000 Manufactured B 107751 St 13.10.09 Hinge Rib Location Loc Qty Loc Code WA04 105716 100 Each 5.0000 Manufactured No ** B 106799 -> 31 SS 13.10.09 Location Loc Qty Loc Code WA004 100412 WA005 69730 82969 85435 88392 D4017-9 100 3.0000 Manufactured Each B107114 - 2x SS 13.10.09 *D4017-9* ** Location Loc Oty Loc Code WA005 3 2 70341 81445

									DQA:	Date:	1 ,
NCR: Yes	/ No				WORK ORDER NON-C	CONFOR	MANCE / UP	DATE	QA Closed:	Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No. NCR No.					Rework Scrap Use-as-is Work Order Update		Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process											·

Landing	Gear	 General		_	 _	_
	Bending .	Bend	Г	Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance	Part Moved	•
	Heat Treat	Countersink		Mislabeled	Positioned Wrong	
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset	-	
	Torque Waves in Extrusion	Drawing		Out of Calibration		
	Turning Sequence	Finish		Out of Sequence		
	Wave/Twist in Tube	Folio		Outside Dimensions		

FAULT CATEGORY

Supplier Training Unapproved August-28-13 12:53:08 PM

Work Order ID: 106229		*1(06229*								
Parent Item: D4017-041			4017-041*	r							
Parent Item Name: Short Basket Ba	ase Assembly (350)	. ,					tart Date Start Qty		_	Date: 8/28/13 d Qty: 1.00	
D3916-041	Manufactured	No		100	Each	8.0000	2	2			
√*D3916-041* Rib Assembly							**	B 102	430 -	2x	
Kio Assembly			Location	Lo	e Qty	Loc Code			إر	413.1	0.09
			WA004		6						,
			104996		6				_		
			WA005		2						
			81444		2						
/D3916-5	Manufactured	No		100	Each	15.0000	1	1	•		
D3916-5							**	B103	9 52	M13	10.09
Digit. No			Location	<u>Lo</u>	c Oty	Loc Code					-
			WA004		10						
			100441		8						
			94698		2						
			WA005		5						
			77142		1						
			82933		4						
D4034-041	Manufactured	No		100	Each	2.0000	1	1		11.	
/ *D4034-041* Aft Upper Rib Assembly							**	T5 100	ر 1951	IS 13.	10.09
			Location	<u>Lo</u>	c Qty	Loc Code					
			WA004		1						
			103356		1						
			WA005		1				<u></u>		
			84048		1						
					i i						

							•			DQA:	Date:	
NCR: Y	'es /	No				WORK ORDER NON-C	ONFORI	MANCE / UP	DATE	QA Closed:	Date:	
Work Orde	er:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	•
Part N	lo					Rework Scrap Use-as-is Work Order Update		Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	l	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
						L						
Root				1	Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause		ate	Step	Qty	C	or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup												•
Other						·						

FAULT CATEGORY Landing Gear General Ovalized Pressure/Forced Bend Grain Bending BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Part Incorrect Broken/Damaged Inspection Incomplete Weld Cracks Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Crushed/Crimped Burrs Cuffs Contamination Maintenance Part Moved Mislabeled Positioned Wrong Countersink Heat Treat Other Cut Too Short Power Loss/Surge Inspection Strip in Tube Misread Drill Holes Ripples in Bend Offset Out of Calibration Torque Waves in Extrusion Drawing Turning Sequence Finish Out of Sequence Folio Wave/Twist in Tube **Outside Dimensions**

Process
Supplier
Training
Unapproved

August-28-13 12:53:08 PM

Parent Item: D4017-041 Parent Item Name: Short Basket Base Ass			16229*						
Parent Item Name: Short Basket Base Ass		^)4	4017-041*						
	sembly (350)						tart Date: 8 Start Qty: 3		Required Date: 8/28/13 Required Qty: 1.00
D4034-043	Manufactured	No		100	Each	3.0000	1	1	. 1
D4034-043 Fwd Upper Rib Assembly							**	107/59	S 13.10.09
			Location	Loc	<u>Oty</u>	Loc Code			
			WA		1				
			103421		1				•
			WA005		2				
			82980		2				
D2581	Manufactured	No		100	Each	77.0000	2	2	
D2581 Mounting Bracket							**	3/030	16 → 2x SY 13·10·09
Mounting Bracket			<u>Location</u>	Loc	Oty	Loc Code			1H12.10.09
			WA004	Loc		Loc Code			2013 10 01
			WA004 103076		77 24				
			103952		39				
			70766		2				
			81253		1				
			82506		2				
	•		83230		3				
			85452		2				
			87706		2				
			99837		2				
D3913-15	Manufactured	No		100	Each	13.0000	1	1	11
D3913-15 Wide Handle Plate				•			**	B 9771	A 13-10.09
			Location	Loc	<u>Oty</u>	Loc Code			
			WA004		13				
	•		104675		8				and the second second
	·		97719		5	•			

NCR: Y	es / No				WORK ORDER NON-	CONFOR	MANCE / UP	DATE			•
									QA Closed:	Date:	
Work Orde	ř:				DISPOSITION	_		AGAINST DE	PARTMENT,	·	1 - · · [7]
Part N NCR N					Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	Τ			Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Ooc/Data quip/Tooling Operator Material Setup											
Other	_					1					
Process Supplier											
Training Unapproved											
Jiiappioved 1		!				AULT CATI	EGORY		l		
Landin	ıg Gear				General						
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend			O/S	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes	Inspec Instruc Maint Mislab Misrea Offset	Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset			tolerance ct ssing Vrong Surge	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
ļ	Torque Waves in Extrusion Drawing						Calibration				
l	Turning S	equence			Finish	Out of	Sequence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

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August-28-13 12:53:09 PM

Work Order ID: 106229		*1	N6229*			÷			
Parent Item: D4017-041			4017-041*						
Parent Item Name: Short Basket	Base Assembly (350)		 (/1/(/1			S	tart Date	8/28/13	Required Date: 8/28/13
						5	Start Qty	: 1.00	Required Qty: 1.00
D4016-1	Manufactured	No		100	Each	60.0000	3	3	
D4016-1 Hinge Half, Base							**	B 1036	114 -> 3x
			Location	<u>L</u>	oc Oty	Loc Code			13.10.09
			WA004		60				_
			100265		8				
			103414		32				<u> </u>
			104200		20				<u> </u>
D4020-3	Manufactured	No		100	Each	1.0000	1	1	•
D4020-3 Mesh (350 Basket Short, Base)							**	B107	784 SS 13-10-10
			Location	L	oc Oty	Loc Code			
			WA		1				
			105061		1				<u> </u>
D4020-11	Manufactured	No		100	Each	7.0000	2	2	
D4020-11 End Mesh, Basket							**	3 107	1053 > 2x
,			Location	L	oc Oty	Loc Code			SS13.10.09
			WA007	_	7				7001010
			102072		4				•
			81442		2				
			84972		1				-
D4021-1	Manufactured	No		100	Each	52.0000	3	3	
D4021-1 Handle Plate							**	B 103	509 → 3r
			Location	L	oc Qty	Loc Code			SY 13-10.09
			WA004		52				
•			100366		17				
	,		100649		4				<u> </u>
			103509		28				
			94596		3			-	<u> </u>

•		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

										QA Closed:	Date:	
Work Orde	ri:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	<u></u>				Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update		nitial	Act	tion	Sign &		
Cause	Date	Step	Qty	,	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling											·	
Operator [
Material												
Setup											_	
Other												
Process												
Supplier												
Training												
Unapproved			ļ ,									:
						AUL	T CATE	GORY				
Landir	ng Gear			_	General		ſ			1		7
,	Bending			<u> </u>	Bend	\vdash	Grain			Ovalized		Pressure/Forced
	_	lot Conce	ntric to	o/s	BOM/Route	\vdash	Hardwa		L	Over/Under		Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged	-	-	on Incomplete		Part Incorred	<u> </u>	Weld
		/Crimped		<u> </u>	Burrs			ions Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			<u> </u>	Contamination	-	Mainte		<u> </u>	Part Moved		
	Heat Treat				Countersink	+	Mislabe		<u> </u>	Positioned V	· · —	7
.		on Strip in	Tube	<u> </u>	Cut Too Short	\vdash	Misread	1		Power Loss/	Surge	Other
					Drill Holes	-	Offset		•			
	_	Waves in I		n 📙	Drawing	-		Calibration				·
		Sequence			Finish	\vdash		Sequence				
	Wave/T	wist in Tul	be		Folio	1	Outside	Dimensions				

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Work Order ID: 106229 *106229* D4017-041 Parent Item: *D4017-041* Parent Item Name: Short Basket Base Assembly (350) **Start Date: 8/28/13** Required Date: 8/28/13 Start Qty: 1.00 Required Qty: 1.00 DAS D2931 150 Manufactured No Each 2,132.000 32 *D2931* ** 9-89 Bumper Location Loc Qty Loc Code GA 134 46064 134 ST021 1998 86435 1998 DAS D4021-5 Manufactured No 150 Each 41.0000 32 ** 9-89 Blanking Plate Location Loc Oty Loc Code ST084 41 103399 34 103829 6 DAS 85065 32 AN3-10A No 150 405.0000 Purchased Each 9-89 *AN3-10A* ** Bolt Location Loc Qty Loc Code ST351 14 124221 3 124858 11 ST513 391 m125709 391 NAS1149DN832 Purchased 150 Each 0.0000 2 2 DAS M126 3/9 Washer

												DQA:	D	ate:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE					
									•			QA Closed:	D	ate:	
Work Order:						DISPOSITION AGAINST DE					DE	EPARTMENT/PROCESS			
Part No						Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite				Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other
Root					Descri	ption of work order update	1	Initial	Ac	ction		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verificati	on	QC Inspector
Doc/Data															
Equip/Tooling															
Operator													i		
Material		4													
Setup		•													
Other							1								
Process															
Supplier															
Training															
Unapproved			İ				<u> </u>								
						F	AUL	T CATE	GORY						
Land	ing (Gear				General		-			_	-		_	7
Bending						Bend	L	Grain				Ovalized			Pressure/Forced
		Centre N	ot Concei	ntric to	o/s	BOM/Route		Hardware				Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete			Part Incorre	ct	L	Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete,	'Unclear		Part Lost/Mi	issing	L	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance			Part Moved			
		Heat Trea	at	•		Countersink		Mislabe	led			Positioned V	Vrong		_
	Г	Inspectio	n Strip in	Tube		Cut Too Short		Misread	1			Power Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

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Work Order ID: 106229 *106229* Parent Item: D4017-041 *D4017-041* Required Date: 8/28/13 Parent Item Name: Short Basket Base Assembly (350) **Start Date: 8/28/13** Required Qty: 1.00 Start Qty: 1.00 DAS MS20600-AD4W3 Purchased No 150 Each 739.0000 2 32 *MS20600-AD4W3* ** 9-89 Cherry Rivets Loc Code Location Loc Qty ST311 606 122151 122452 123525 288 124231 310 WA003 133 107939 133 DAS MS21042L3 150 7,008.000 No Each Purchased 32 ** *MS21042L3* Loc Code Location Loc Qty 13/10/21 (1) FP001 3 122141 3 GA 18 122452 18 ST314 604 111668 1 117885 32 55 119017 138 119075 123265 43 M126036 335 ST506 1383 123900 912 124291 471 ST510a 5000 M126275 1000 M/26333 M126333 4000

										DQA:	Date:		
NCR: Y	es / No				WORK ORDER NON-CONFORMANCE / UPDATE					QA Closed:	Date:	:	
					T	-				QA Closed.	Date.		
W. Louis					DISPOSITION AGAIN				NST DE				
Work Orde	·				Rework	Skid-tube Crosstube			I	Water Jet	Engineering		
Part N	lo.				Scrap	Skid-tube Crosstube Machining Small Fab			Prod. Eng. Coor.		Quality		
rait iv					Use-as-is			noforming Finisl	<u> </u>	4	re/Packaging	Other	
NCR N	lo.				Work Order Update			Large Fab Compo	~⊢	1100,3101	Supplier		
1101111	···				Work Order opadie	1				J	- app	اــــا	
Root				Descri	ption of work order update	Ī	nitial	Action		Sign &			
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng			Date	Verification	QC Inspector	
Doc/Data													
Equip/Tooling			İ			1							
Operator [
Material [`									
Setup													
Other						l							
Process [
Supplier						ļ							
Training													
Unapproved													
					F/	AUL	T CATE	GORY					
Landin	ng Gear				General	_	1			7		1	
Ļ	Bending				Bend	Ш	Grain			Ovalized		Pressure/Forced	
Ļ	Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
ļ	Cracks				Broken/Damaged	-	1	on Incomplete		Part Incorred	·	Weld	
ļ	Crushed/	Crimped			Burrs	-		ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled	
Ĺ	Cuffs				Contamination		Mainte	nance		Part Moved			
1	Heat Trea	it			Countersink		Mislabe	led		Positioned Wrong			

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Picklist Print

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Work Order ID: 106229

106229

Parent Item:

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

D4017-041

Start Date: 8/28/13

Required Date: 8/28/13

Start Qty: 1.00

Required Qty: 1.00

12

DAS

NAS1149F0332P

Purchased

150

Each

9,540.000 ** 12

32 9-89

NAS1149F0332P

Washer

Location	Loc Oty	Loc Code	
GA	182		
122063	182		
ST294	158		
122063	158		
ST295	3		·
123352	3		***************************************
st510	4197		-
123900	4197		123500
ST510a	5000		
125646	5000		

				DQA:_	Date: _	· · · · · · · · · · · · · · · · · · ·
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE			

								QA Closed: Date:							
Work Orde	er: _					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No						Rework Scrap Use-as-is Work Order Update	The	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	b Prod. Eng. Coor. Quality g Rec/Store/Packaging Other					
Root					Descri	ption of work order update	Initial	A	ction	Sign &					
Cause		Date	Step	Qty		or Non-conformance	Chief Er	ng Des	cription	Date	Verification	QC Inspector			
Doc/Data	\Box														
Equip/Tooling								ļ							
Operator															
Material															
Setup	Ш														
Other	Ш														
Process															
Supplier	Ш														
Training															
Unapproved															
						F	AULT CA	TEGORY							
Landi	ng G	iear				General				,	_				
	Ш	Bending				Bend	Grain	ı	<u> </u>	Ovalized	_	Pressure/Forced			
	Щ	Centre Not Concentric to O/S			o/s	BOM/Route	\vdash	Hardware			tolerance	Temperature/Cure			
	Ш	Cracks				Broken/Damaged	Inspe	ction Incomplete		Part Incorrect Weld					
		Crushed/Crimped				Burrs	₩.	ictions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled			
	${f H}$	Cuffs			_	Contamination	\vdash	tenance		Part Moved					
	\vdash	Heat Treat			_	Countersink	Misla	beled		Positioned V		_			
	-	Inspection Strip in Tube				Cut Too Short	Misre			Power Loss/	Surge	Other			
	Ripples in Bend				<u> </u>	Drill Holes	Offse								
}		Torque W			n	Drawing		f Calibration				·			
	Ш	Turning S	equence			Finish	Out	f Sequence							
	Wave/Twist in Tube				1	Folio	I Outci	de Dimensions							









